Presentation No. Twelve

QUALITY CIGARETTE MANUFACTURE

Mr. John Nowers

MOLINS TOBACCO MACHINERY LTD.

Available: Transcript - Yes
Pre-conference Excerpt - Yes

Mr. Nowers explained the basic functions of the tobacco feed section (especially the hopper) of a cigarette maker. Also how what is put into the hopper affects the final cigarette makeup. His ideal makeup of an American blend cigarette would consist of: 25% longs, 55% medium, 20% shorts, and no fines. Originally, wide tobacco feeders, by carding and winnowing, attempted to gravity feed a uniform depth of loose tobacco onto a slow moving cigarette forming belt. About 1960, the Mark 8 pneumatic feed hopper was introduced. An oversized tobacco ribbon were suction applied to the cigarette belt from a more narrow faced hopper. Excess ribbon height was trimmed for uniformity and the excess returned to the tobacco feed. Cigarette makers were running at about 2000 cpm. By the early 1970's speeds were at 4000 cpm; by the early eighties, 7000 cpm; and the target for the near future is 8000 cpm. Mr. Nowers ignored the Mark 9 and 9-5 and went directly into describing newly developed assets of the Mark 10. Among these are double winnowing for more uniform distribution within the tobacco ribbon; a new suction enclosure at the maker exit to cut down on the number of chokes; and the generous use of microprocessors. Mr. Nowers also pointed out the advantages of their mass flow tip-turner resulting in less violent handling and lower centrifugal forces than individual cigarette turners: important, as cigarettes get more delicate and more subject to loose ends.

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